

Date: Tuesday, 9/25/2007 10:11:43 AM
User: Kim Johnston

Process Sheet

split
SB 07/11/14

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : LUG ASSEMBLY

Job Number : 34841 -2

Estimate Number : 10913

P.O. Number : N/A

This Issue : 9/25/2007

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Type : LARGE FAB ASSY

Previous Run : 32891

Part Number : D3405043

Drawing Number : D3405 REV A

Project Number : N/A

Drawing Revision : A

Material : N/A

Due Date : 10/10/2007

Qty: 30 Um: 16 Each

Written By :

Checked & Approved By :

Comment :

Est A05.09.01 New issue KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S11GA

304/316 .125 Sheet



Comment: Qty.: 0.1617 sf(s)/Unit Total : 2.5872 sf(s)

S.1744

304/316 .125 Sheet

(M304S11GA)

Batch: 104934

IB 07-10-2

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3405

Dwg Rev: A

IB 07-10-2

Prog Rev: A

2-Deburr if necessary

IB 07-10-2

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Enatoley (32) counter

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form using DT8204 as per Dwg D3405

SB 07/11/14 (3)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 34841

Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/11/16 (3)

* Rush for k. + completion.

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

GHW Lug

Pick:

Qty Part number Description Batch

1 D3404-1 Lug

A/R SS Rod

D26536
M102421

FC 07/11/16 (3)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-043

FC 07/11/16 (3)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/14/16 (3)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/14/16 (3)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105914

BR 07-11-16 (3)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

3X
07/14/16

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7/11/16 SC (3X)

Tuesday, 9/25/2007 10:11:43 AM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 34841

Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description:

140

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(3)
DART/15

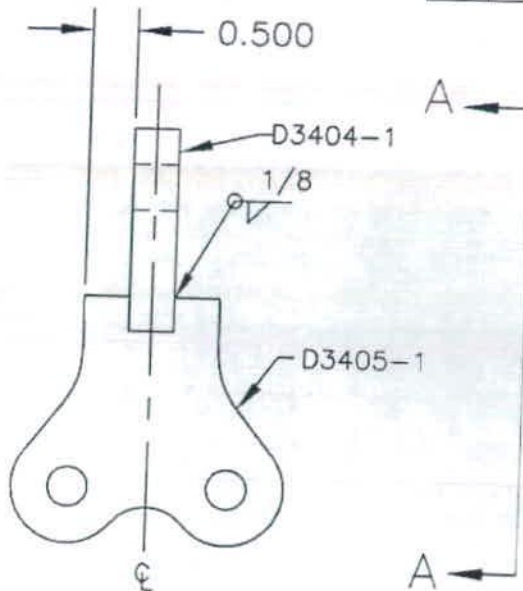
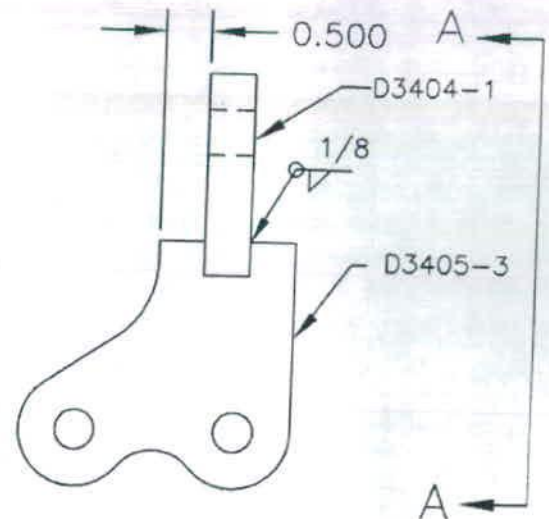
Job Completion



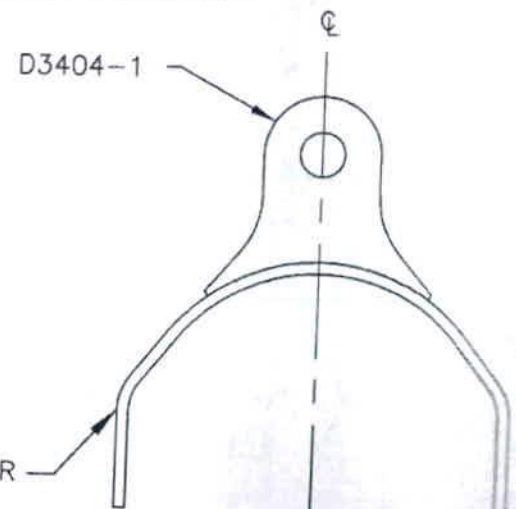
U 07-11-17

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. SHEET 1 OF 1
DATE 05.03.08	TITLE GHW LUG ASSEMBLY		SCA 1
A	05.03.08	NEW ISSUE	

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1		D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

D3405-1 OR
D3405-3**D3405-041/-043 LUG ASSEMBLY**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

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